

Date: Wednesday, 9/13/2006 4:30:40 PM
 User: Kim Johnston

Process Sheet

Split

SB 06/10/05

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : EYEBALL ADAPTER
Job Number : 28528	
Estimate Number : 12246	
P.O. Number : N/A	Part Number : D3480041
This Issue : 9/13/2006 S.O. No. : N/A	Drawing Number : D3480 REV.A UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : A
Previous Run : 26959	Material : N/A
Written By : _____	Due Date : 10/6/2006
Checked & Approved By : _____	Qty: 4 Um: Each
Comment : est rev. A 06.02.07 new issue EC	

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

D34805

EYEBALL ADAPTER FLANGE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D3480-5	Flange	B 28576

2.0

D34803

tube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D3480-3	Tube	B 28575

SB 06/10/10

3.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spot weld as per dwg D3480

2-Cut tube flush as per dwg D3480

3-Deburr

4.0

QC5/11

INSPECT WORK/INSPECT SPOT WELD



Comment: INSPECT WORK/INSPECT SPOT WELD

SB 06/10/10 (2)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EYEBALL ADAPTER

Job Number: 28528

Part Number: D3480041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with a permanent fine point marker and Stock

Location:

57444

RB 06/10/10

(2)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

RB 06/10/11

Job Completion



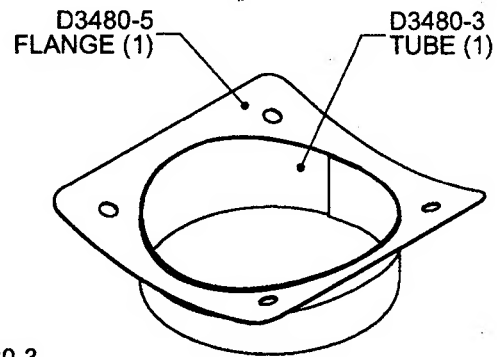
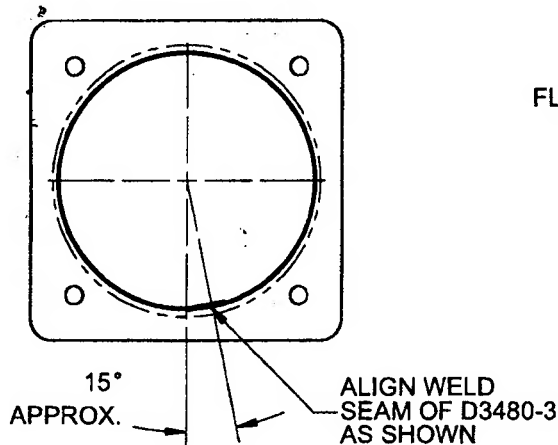
W To 10/11



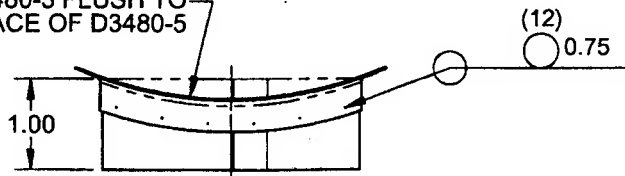
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3480	REV. A SHEET 1 OF 6
DATE 06.02.06		TITLE EYEBALL ADAPTER	SCALE 1:2
A	06.02.06	NEW ISSUE	

[Signature] 06.04.03

UNDER REVIEW
06.05.17 *[Signature]*



SPOT WELD PARTS. THEN CUT D3480-3 FLUSH TO SURFACE OF D3480-5



D3480-041 EYEBALL INLET ADAPTER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. _____

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3480-041	EYEBALL INLET ADAPTER
1	D3480-3	TUBE
1	D3480-5	FLANGE

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NO. 31

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Melanie Boucher
Joint Welding Procedure Spot Welding
Part number and Job number D 3480-041 B 28528

TEST WELDS REQUIRED

BASE METAL 304 26G WELDING PROCESS Spot
Penetration Complete ☐ Partial ☐ Single Weld ☐ Double Weld ☐
Current AC ☐ DC ☒ Backing YES ☐ NO ☒ ✓

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

N/A

Crossbolt Spacer Welded into _____ Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐

Crossbolt Spacer Pass ☐ Fail ☐ N/A

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/10/10 Qualifier Sylvie Boucher